

Work Order ID 65418

January 17, 2011 10:05:03 AM



Page 1

Item ID: D2232-3

Accept



Setup Start



Revision ID:

Item Name: Basket Hinge

Stop



Start Date: 1/17/11 Start Qty: 6.00



Cust Item ID:

Required Date: 1/20/11 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: CL Date: 1/16/11

Tooling:

Date:

Run Start



QC: _____ Date: _____

SPC (Y/N): _____

Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2232

Rev C

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2232 ☐ Dwg Rev: C ☐ Prog Rev: C ☐ 2-
Deburr if necessary

1B11-1-20

304 -125

(6)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

1B11-1-20

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

Sublot 20

(6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 65418

January 17, 2011 10:05:03 AM



Page 2

Item ID: D2232-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Basket Hinge

Start Date: 1/17/11 Start Qty: 6.00



Cust Item ID:

Required Date: 1/20/11 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

0.00



Small Fab

0.00

Small Fab

Memo

Small Fab

Deburr

NA

140

0.00



Identify as per dwg & Stock Location: WA

0.00

Packaging

Memo

Packaging

*****STOCK IN BASKET CELL*****

SAD
11-01-20

6

150

0.00



QC21- Final Inspection - Work Order Release

0.00

QC

Memo

Quality Control

CK 11/01/24
MF
11-01-21

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 17, 2011 10:05:02 AM

Page 1

Work Order ID: 65418



Parent Item: D2232-3



Parent Item Name: Basket Hinge



Start Date: 1/17/11

Required Date: 1/20/11

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP B 01.06.07 Now laser cut EC
IPP Rev:C Now on Waterjet 06-10-26 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA 		Purchased	No			100	sf	29.5003	0.0694	0.438316			
304/316 0.125 Sheet												B 11-1-20	

Location

Loc Qty

Loc Code

MAT

29.5003

114799

0.5003

116437

29

116437

⑥

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

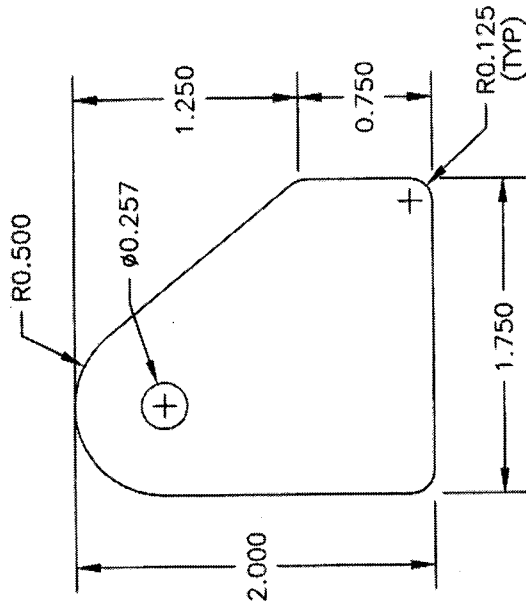
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

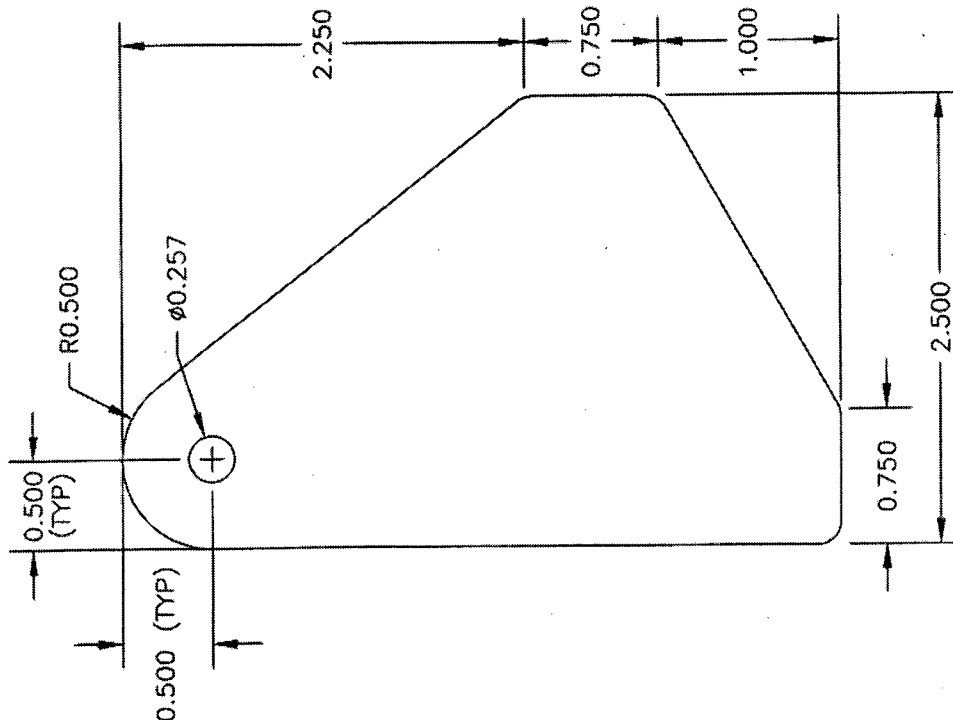


DESIGN	DRAWN BY <i>KIE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>MO</i>	APPROVED <i>KIE</i>	DRAWING NO. D2232	REV. C SHEET 1 OF 2
DATE 98.04.28		TITLE BASKET HINGE	SCALE 1:1
A	94.05.12	NEW ISSUE	
B	96.01.02	ADDED -5 AND -7	
C	98.04.28	0.125 THICK WAS 0.063	

RELEASED
98.05.05 KE



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 65418
CL11/10/17

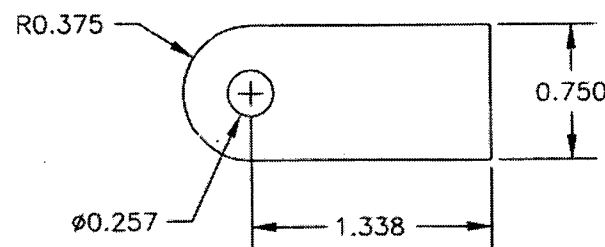


MATERIAL: AISI 304/316 SS 0.125 THICK



DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	REV. C
CHECKED	APPROVED	DRAWING NO. D2232	SHEET 2 OF 2
DATE 98.04.28		TITLE BASKET HINGE	SCALE 1:1

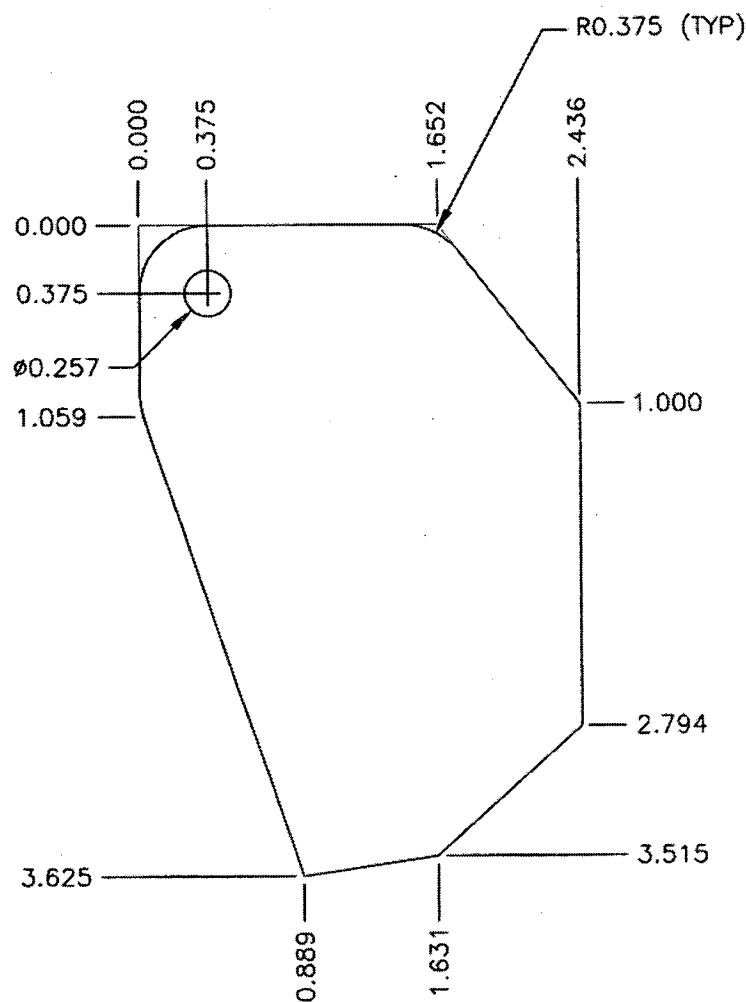
RELEASED
98.05.05 KE



D2232-7

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 65418

CL 11/01/17



D2232-5

MATERIAL: AISI 304/316 SS 0.125 THICK

